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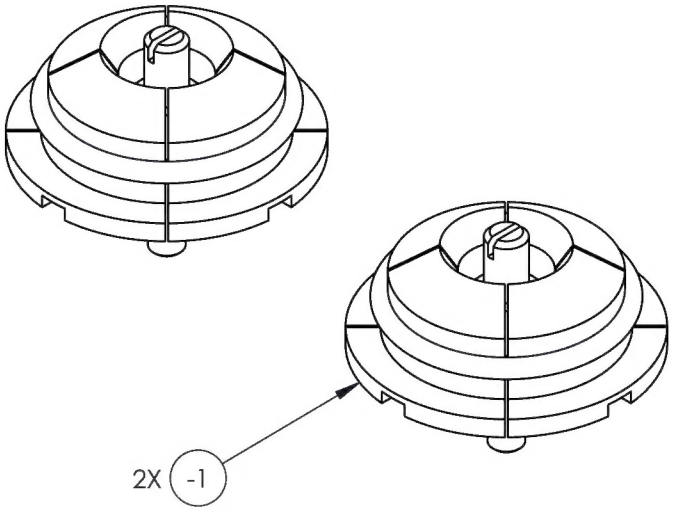
REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	5/24/2016	DPD	JAG



NOTE:
REF. EUROCOPTER T/N: 105-41069W3.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING TOOL ASSEMBLY			2
	4		-3		STAKING INSERT	4140/4142		3
	1		-5		POSITIONING SCREW	4140/4142		4
	1	B/O	-7		O-RING	BUNA-N	Ø3mm X 30mm I.D. (MCMASTER-CARR #1174N608)	2
	ASSY -1							

DART AEROSPACE

TITLE: STAKING TOOL

DWG NO. RBE105-41069W3 REV 1

MAT'L
HEAT TREAT
FINISH
SPEC

DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL: EC145

SCALE 1:1 DATE 1/19/2016 SHEET 1 OF 4

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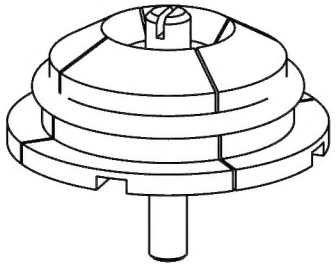

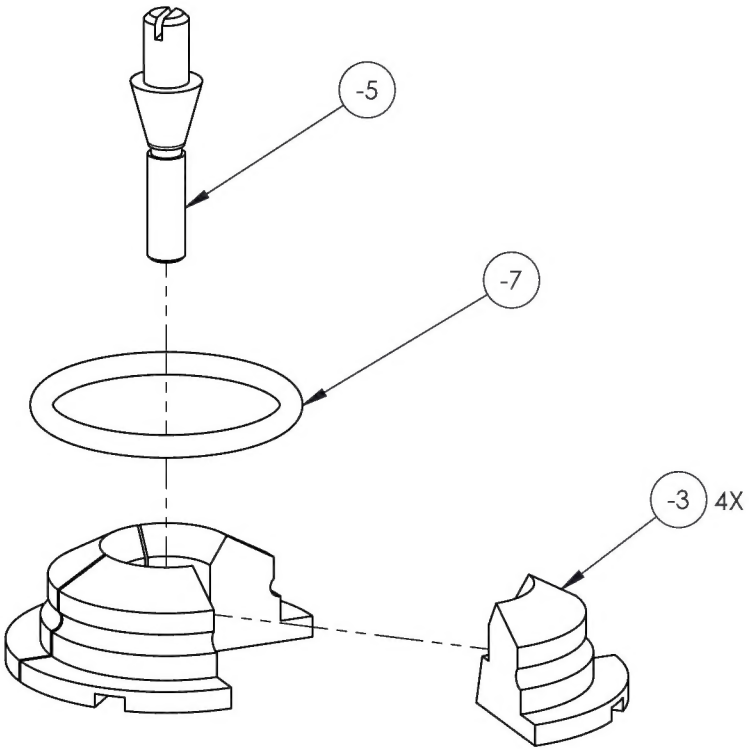

-1

STAKING TOOL ASSEMBLY

DART AEROSPACE

TITLE: STAKING TOOL

DWG NO.: RBE105-41069W3-1 REV: 1

MAT'L:
HEAT TREAT:
FINISH:
SPEC:

DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL: EC145

SCALE: 1:1 DATE: 1/19/2016 SHEET 2 OF 4

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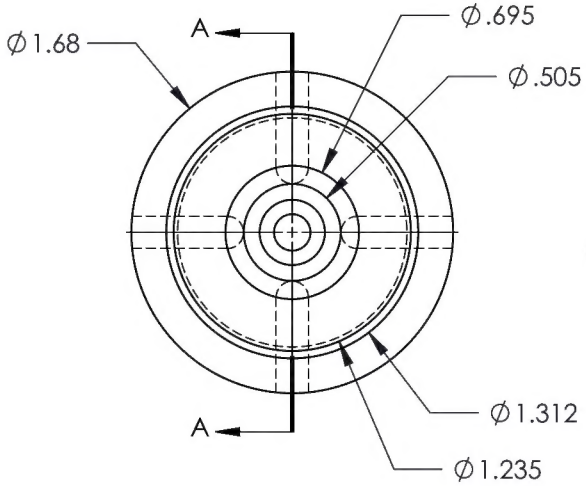
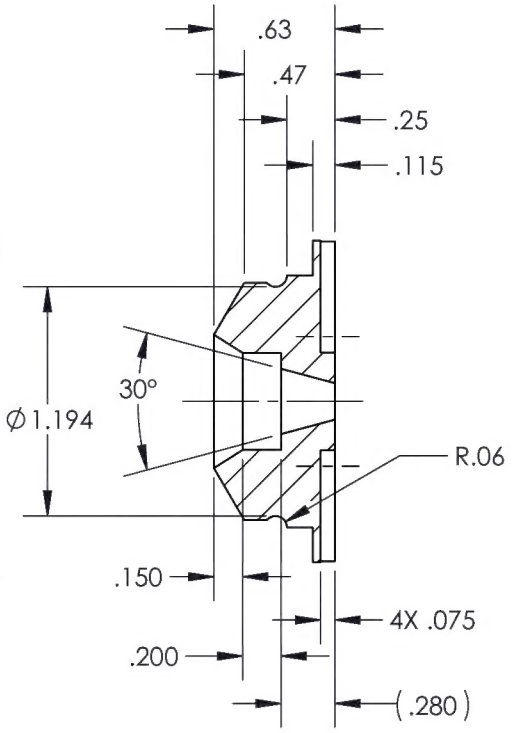
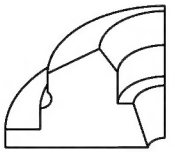
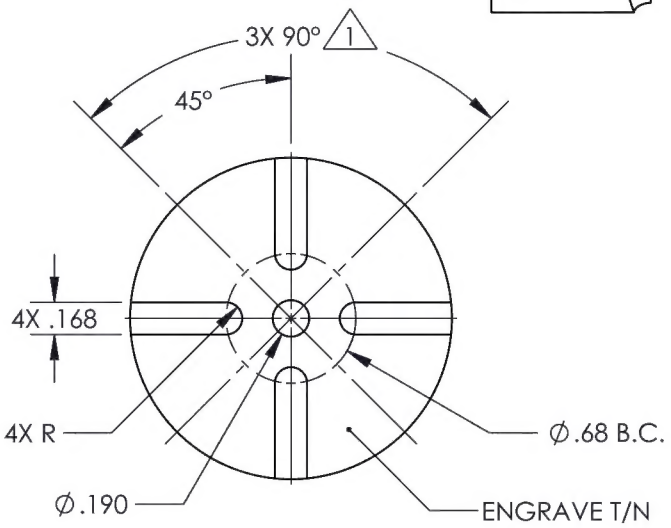
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED





SECTION A-A





HIDDEN LINES
OMITTED FOR CLARITY

NOTE:

1 EDM TO SPLIT INTO 4 EQUAL PIECES.

DART AEROSPACE

TITLE	STAKING TOOL
DWG NO.	RBE105-41069W3-3
REV	1
MAT'L	4140/4142
HEAT TREAT	RC 50-55
FINISH	ZINC PLATE
SPEC	ASTM B633 TYPE I SC 2
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:1
DATE	1/19/2016
SHEET	3 OF 4

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL
EC145

-3

STAKING INSERT

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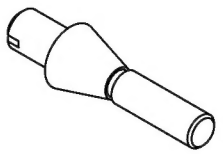
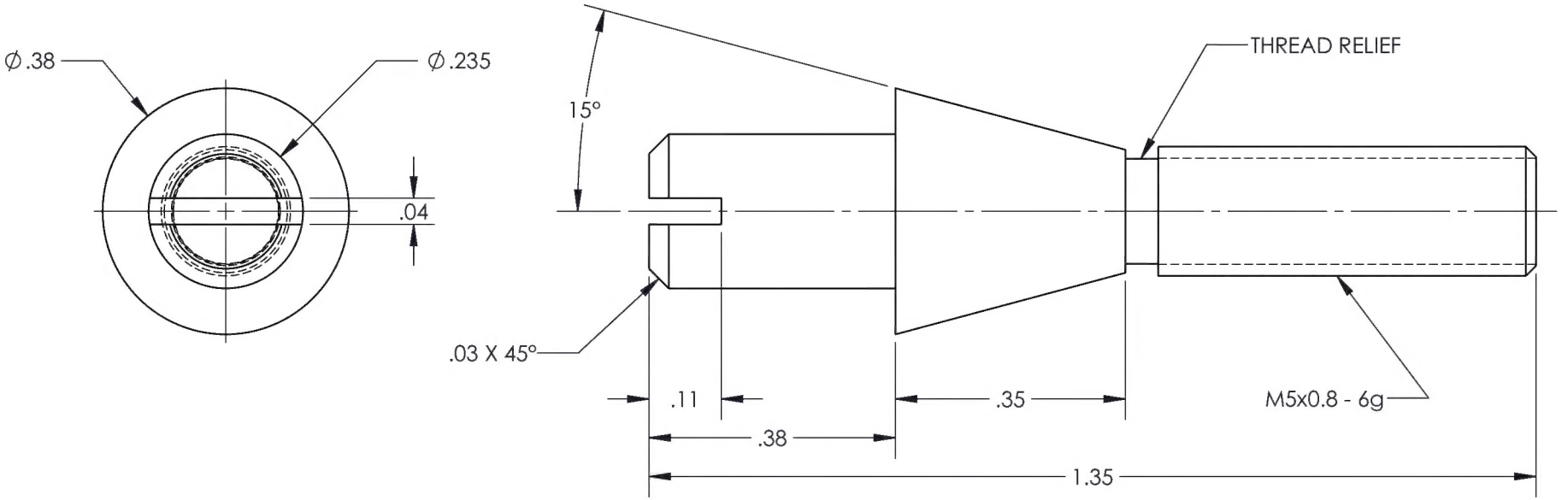
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED





-5

POSITIONING SCREW

DART AEROSPACE

TITLE	STAKING TOOL
DWG NO.	RBE105-41069W3-5
REV	1
MAT'L	4140/4142
HEAT TREAT	RC 48-55
FINISH	ZINC PLATE
SPEC	ASTM B633 TYPE I SC 2
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	4:1
DATE	1/19/2016
SHEET	4 OF 4

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL
EC145